

Date: Wednesday, 6/6/2007 1:58:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 32803		
Estimate Number	: 10775		
P.O. Number	: N/A	Part Number	: D32081
This Issue	: 6/6/2007	Drawing Number	: D3208 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A1
Previous Run	: 28641	Material	: N/A
Written By	:	Due Date	: 6/25/2007
Checked & Approved By	: <u>7/07.06.07</u>	Qty:	10 Um: Each
Comment	: Est: B 04.05.25 Material changed for Step 4 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1727 sf(s)/Unit Total: 1.7273 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)

Note: To be made in multiples of 10

Batch: M103039 (8X) M104025 (2X) FF 07-07-23 10

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 4.038" X 5.340" grain along 4.038"

Identify for D3208-1

FF 07-07-23 10

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and Fillet D3208-1 corner as per Dwg D3208

Identify as D3208-1

FF 07-07-23 10

4.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr D3208-1

Form D3208-1 as per Dwg D3208

Polish any marks on part within 01. of Dwg D3208

SB 07-09-21 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 32803

Part Number: D32081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 07/09/24 (10) counters

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-24 (10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Sp 07/09/25 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5177*

Sp 07/09/25 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/25 (10)

Job Completion



in 07-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

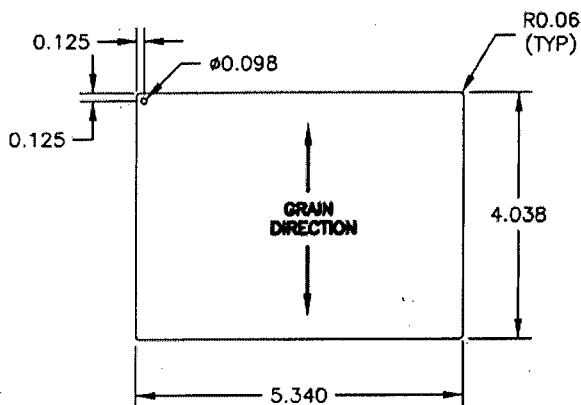
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

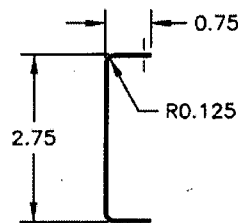


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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	04.05.25	CHANGE DIM; NOTE 3) CHANGE	

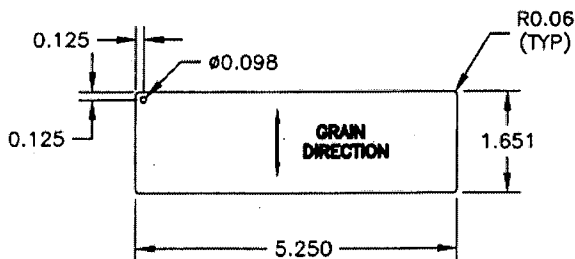
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04.04.05



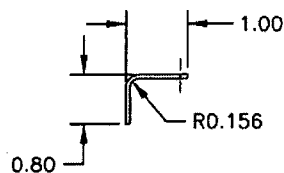
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
 - 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
 - 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
 - 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
 - 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 7) ALL DIMENSIONS ARE IN INCHES
- AI 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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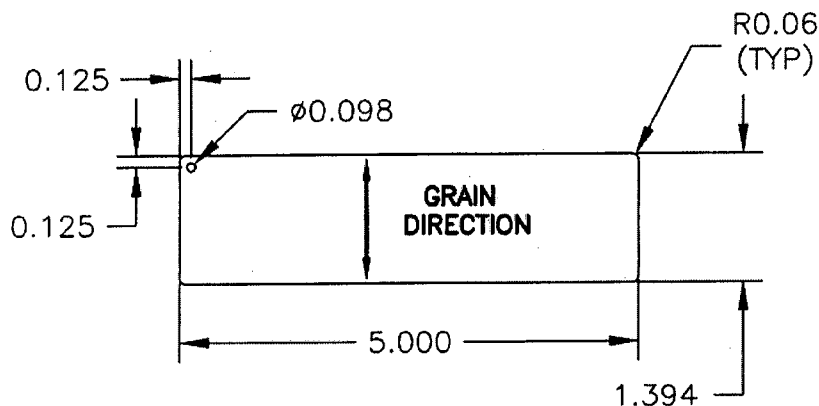
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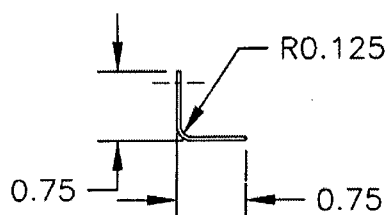
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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05

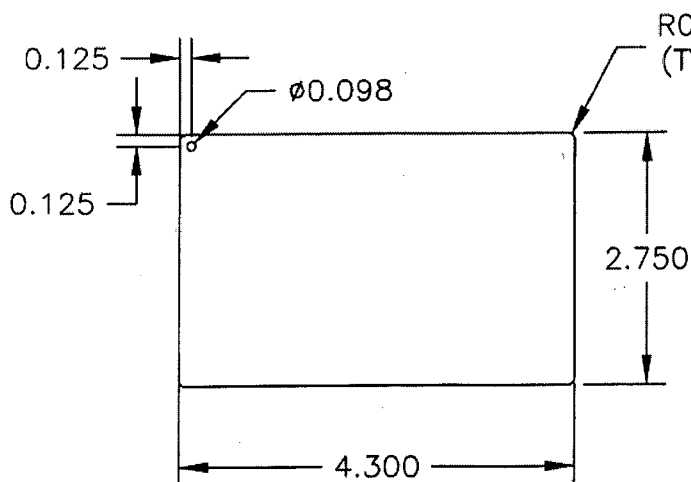


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**D3208-5 MOUNT ANGLE
FLAT PATTERN**

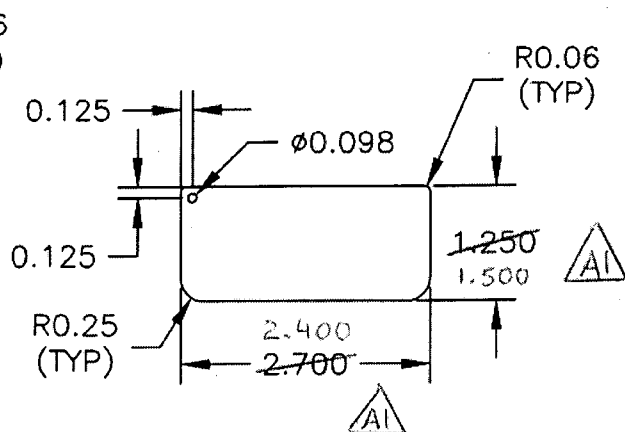


**D3208-5 MOUNT ANGLE
BEND DETAIL**



2

D3208-7 FILLER



2

D3208-11 FILLER

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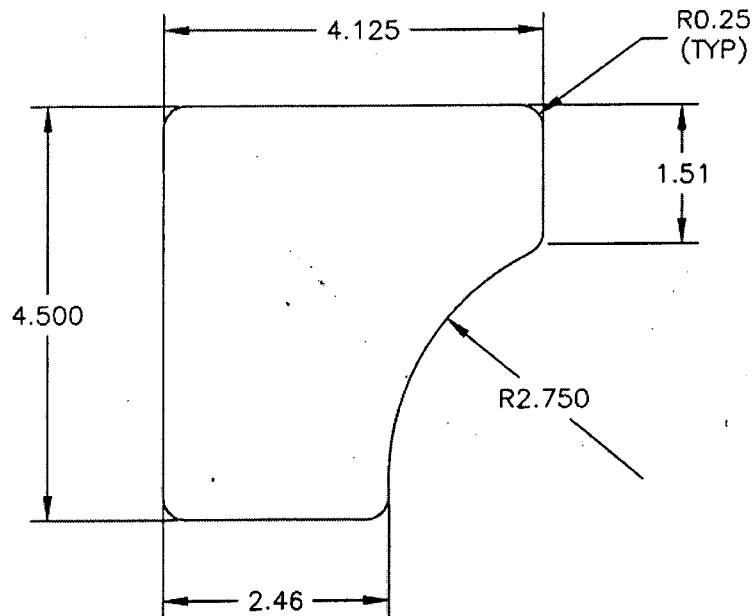
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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D3208-9 DOUBLER

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